



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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PRELIMINARY ISSUE

D5732-1

Job Sheet 197860



Part No: D5732-1

Job Qty: 2 pcs

Part Name: Bearpaw



Part Weight: 0 lbs

Job Created: 7/18/19

Due Date: 8/20/19

Type: SOLD

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: D5732 PRELIM-REV.A IPP REV.A NEW ISSUE JFS 19/07/16 VERIFIED BY:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE DATE: JUL 18 2019

RELEASED: 68

DATE: OCT 11 2019

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Waterjet - Omax - 1	2 pcs	8/20/19		0.17	1.00	Waterjet - Flow	OK 19/10/01
							Waterjet - Omax	
110	HAAS 4 Axis - B4B	2 pcs	8/20/19		1.00	5.00	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	OK 19/10/10
120	QC 2	2 pcs	8/20/19		0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	OK 19/10/10
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	

PRIORITY

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	2 pcs	8/20/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
140	Packaging 3-1 - Stock - B4B	2 pcs	8/20/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B

D. 19-10-11

See
HarcéDAS
68
9-89
OCT 11 2019DAS
21
9-89

OCT 11 2019

7/18/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

150 QC 21 - SA		2 pcs	8/20/19	0.00 0.00	Packaging 3 - 26 - B4B	
					QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-07 OCT 11 2019
Part Op 100 - Cut blank as per D5732-1 waterjet blank. Descriptions: 110 - 1-Inspect material for defects or damage prior to machining. 2-Machine as per Folio FC891 and Dwg. 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Identify as per dwg & Stock Location: _____ 150 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	16 sf (8 ea)	100-Waterjet - Omax - 1	S154152		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Waterjet - Omax - 1	MUHMWB10	16	873	0		
Part Specifications						
Specifications could not be found.						

Plex 7/18/19 7:23 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	197860
Description: Bear Paw		Part Number:	D5732-1
Inspection Dwg: D5732	Rev: A	Page 1 of 1	

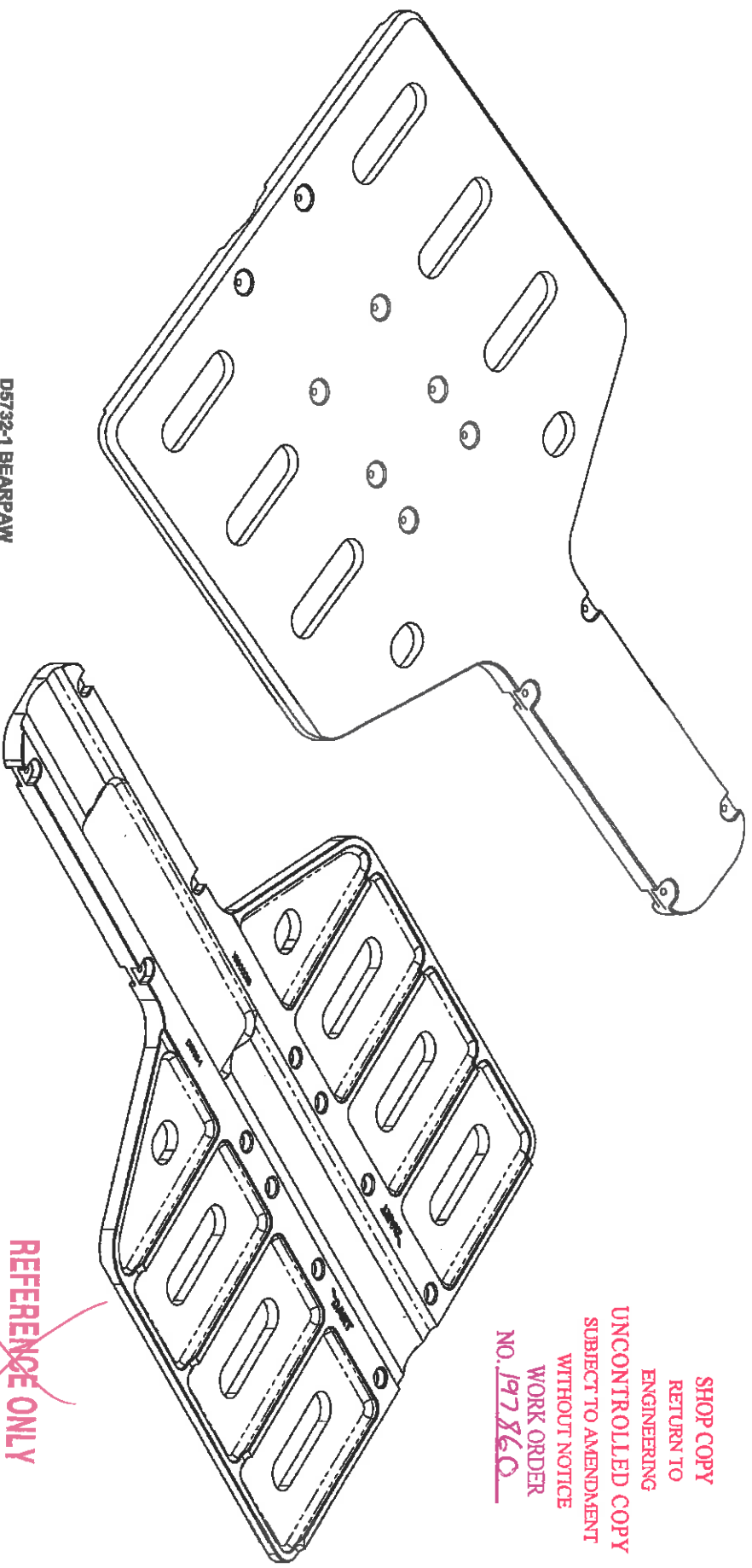
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.500	± 0.030	36.50	/		tape	
5.500	± 0.030	5.503	/		vern	mm L-05
24.00	± 0.030	24.00	/		tape	
10.24	± 0.030	10.237	/		Heigh G	31006
2.76	± 0.030	2.753	/		vern	mm L-05
5.00	± 0.030	5.01	/		"	
2.09	± 0.030	2.091	/		"	
6.000	± 0.010	6.002	/		"	
4.688	± 0.010	4.688	/		"	
.864	± 0.010	.867	/		Heigh G	31006
.915	± 0.010	.916	/		vern	mm L-05
.300	± 0.010	.305	/		dept G	
.806	± 0.010	.808	/		Heigh G	31006
.800	± 0.010	.800	/		vern	mm L-05
.400	± 0.010	.400	/		Dept G	
Ø.261	± 0.001	.262	/		vern	mm L-05
6.400	± 0.030	6.400	/		"	
3.52	± 0.030	3.515	/		"	
0.950	± 0.030	0.947	/		"	
0.740	± 0.030	0.740	/		"	
0.500	± 0.030	.501	/		"	
0.460	± 0.030	.455	/		"	
0.700	± 0.030	.697	/		"	
0.240	± 0.030	.242	/		dept G	
300x45	$\pm 0.016 \times 0.05$	300x45	/		vern	mm L-05
1060x45	$\pm 0.010 \times 0.05$	1065x45	/		"	
R.250	± 0.010	.250	/		AG	
R.030	± 0.010	.03	/		"	
.380	± 0.030	.375	/		vern	mm L-05

Measured by: mm L	Checked by: B.R.	QC Inspector: 68
Date: 19/10/10	Date: 19-10-11	Date: OCT 11 2019

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



D5732-1 BEARPAW

- NOTES:**
- 1) MATERIAL: UHMW BLACK TYVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMB100
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK: SHARP EDGES: N/A
 - 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D5732-1" AND S/N "SXXXXXX"
0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD AS SHOWN
 - 7) WEIGHT: 10.77 lbs
 - 8) ENGRAVE DART LOGO AS SHOWN 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
 - 9) ALL NON DIMENSIONED FEATURES PER CAD FILE D5732-1-REV A.STP

APPROVED

REV.	A	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN	RF		DART AEROSPACE USA, INC.		
DRAWN	RF		HILLBORO, OR		
CHECKED	PM				
ENG. APPR.	RQ		D5732		
APPROVED	DSW		TITLE		
DATE	19.05.22		BEARPAW		
			SCALE		
			NTS		

REFERENCE ONLY

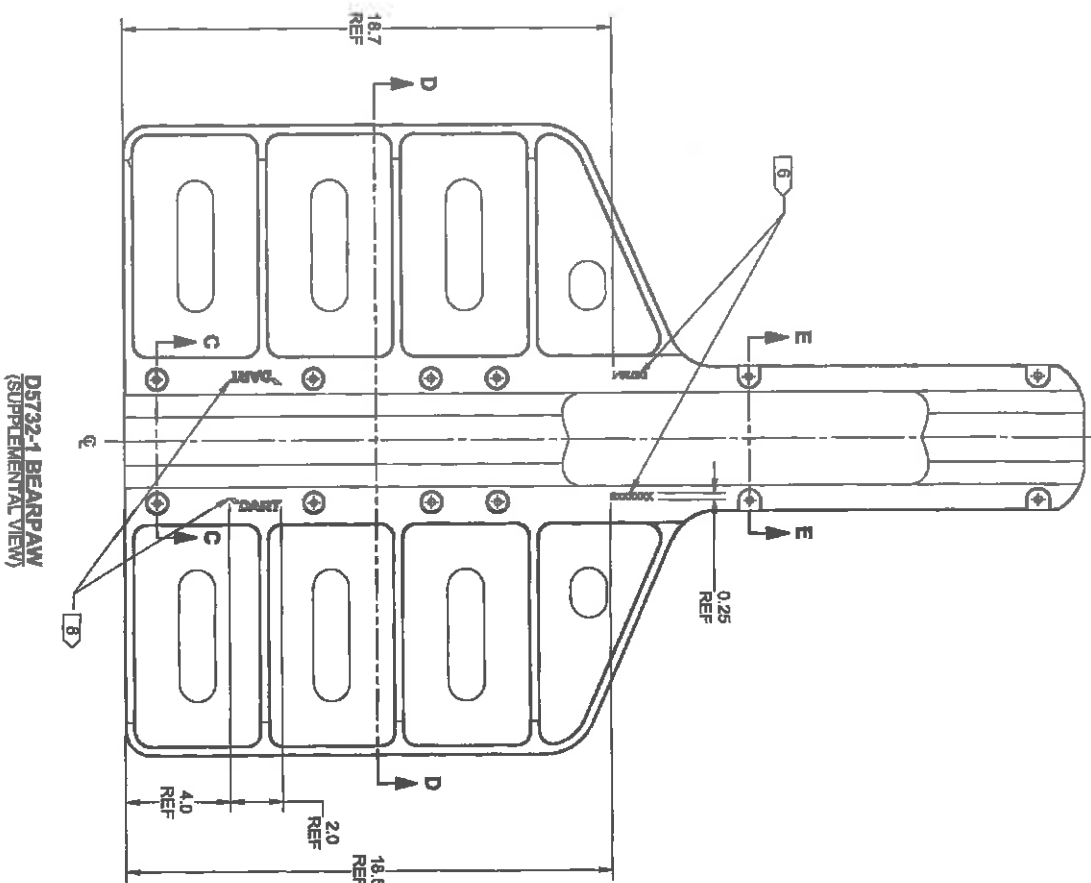
SNP
16/09/20

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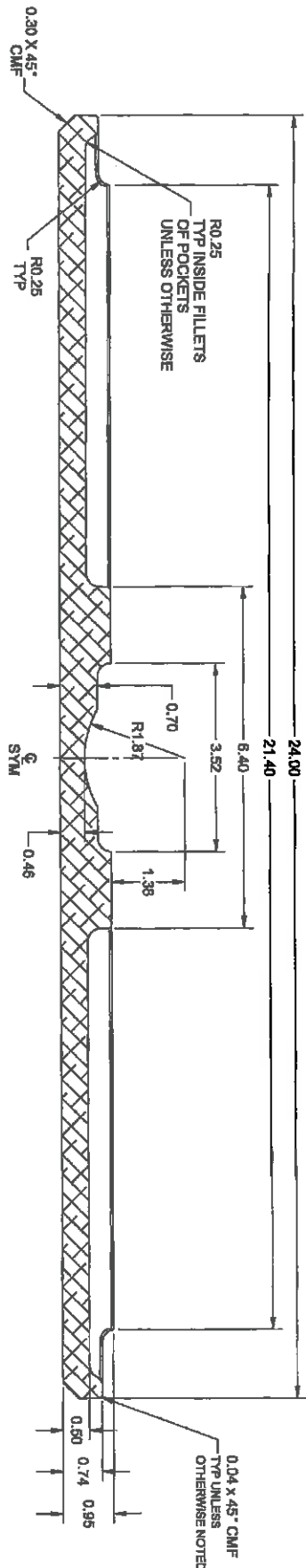
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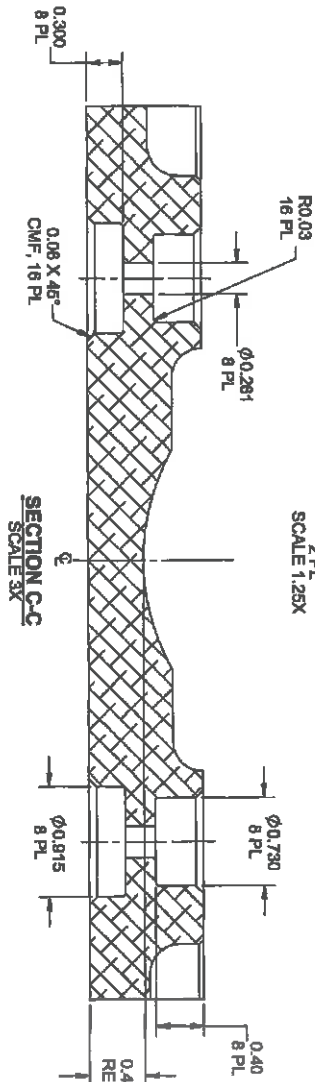
APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	HILLSBORO, OR
CHECKED	PM	DRAWING NO. D5732
MFG. APPR.	RQ	REV. A
APPROVED	DSW	SHEET 3 OF 4
DATE	19.06.22	SCALE NTS
		BEARPAW

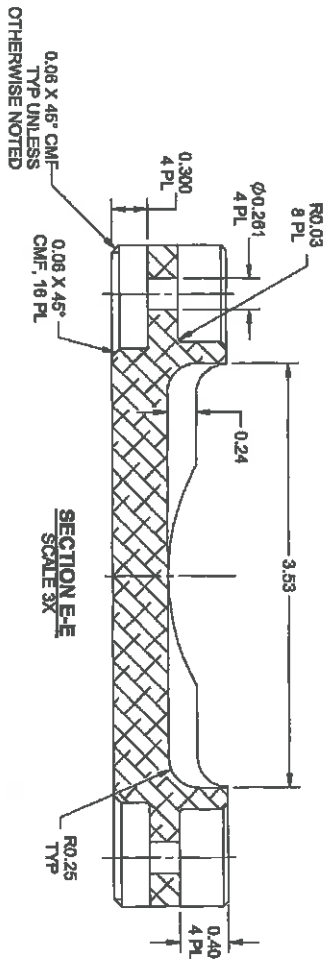
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SECTION D-D
2 PL
SCALE 1.25X



SECTION C-C
2 PL
SCALE 3X



SECTION E-E
SCALE 3X

APPROVED

DESIGN	RE	DATE	19.05.22
DRAWN	RF		
CHECKED	PM		
INFG. APPR.	RQ		
APPROVED	DSW		
DE APPR.	DS		
	BEARPAW		
	TITLE		
	D5732		
	REVISION		
	SCALE		
	NTB		

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